

Date: Tuesday, 19/08/2008 4:07:16 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASE ASSEMBLY
 Job Number : 41509
 Estimate Number : 13419
 P.O. Number :
 This Issue : 19/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LARGE FAB ASSY
 Previous Run : 40506
 Part Number : PB674300147
 Drawing Number : B6743001 P.5/ 15
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 18/09/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JUL 08.8.20
 Comment : Est Rev:A 08-06-25 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D344011 Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)
 Gusset 3 41553

2.0 PB6743001143 Square Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)
 Square Tube 4 x 40604, 4 x B41559

3.0 PB6743001141 Square Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)
 Square Tube 3 40603, B41908 x 4 mx ST

4.0 PB6743001139 Square Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Square Tube 2 x 40601, 2 x 41557ST

5.0 PB6743001315 Hook



Comment: Qty.: 3.0000 Each(s)/Unit Total : 48.0000 Each(s)
 Hook batch:- B41918

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASE ASSEMBLY

Job Number: 41509

Part Number: PB674300147

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld as per dwg B67-43001 using jig

08-09-25

4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/05 (x)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-25 (1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 257

8/9/05

(4x)

SIP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

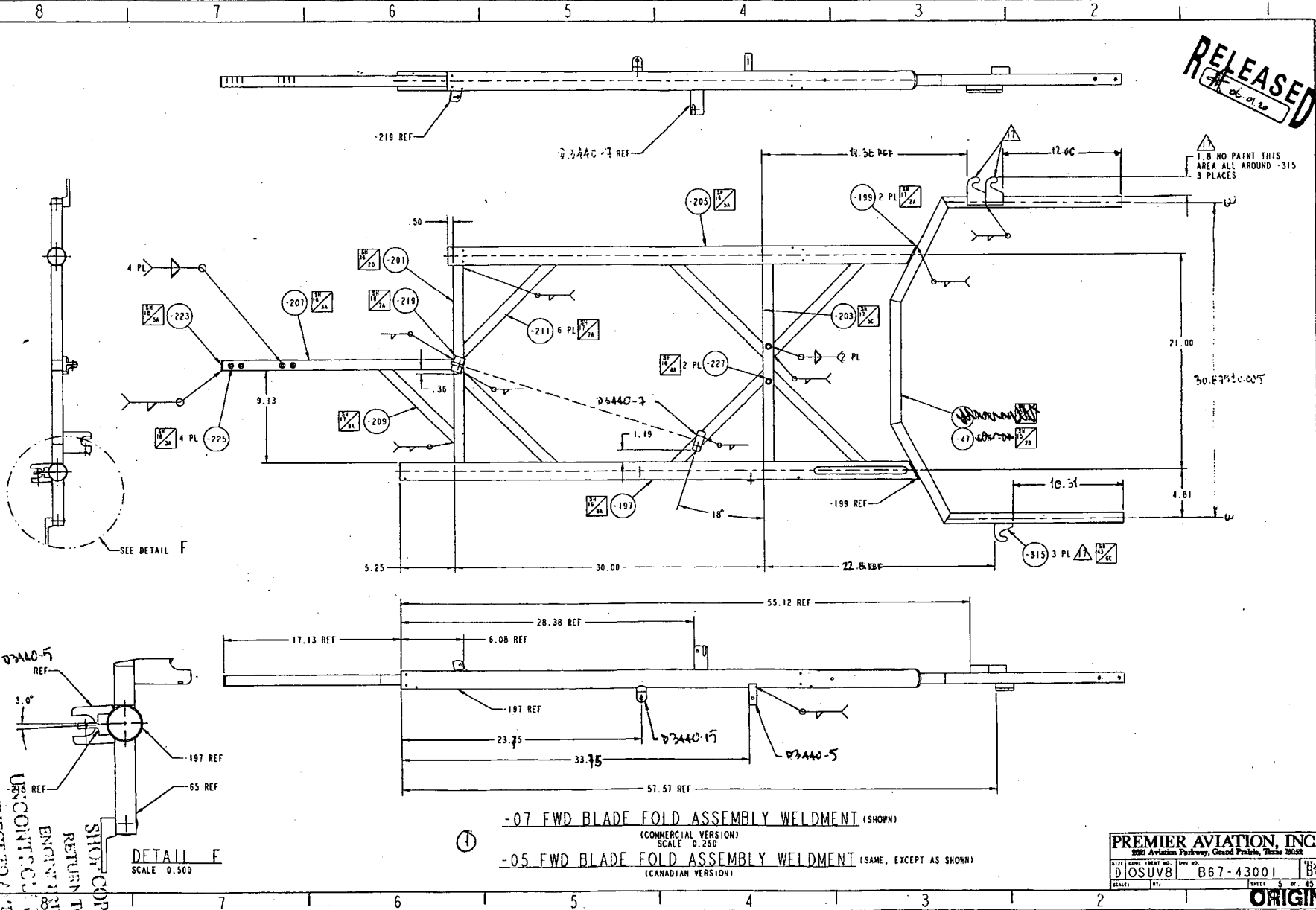
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
16.01.20



-07 FWD BLADE FOLD ASSEMBLY WELDMENT (SHOWN)

(COMMERCIAL VERSION)
SCALE 0.250

-05 FWD BLADE FOLD ASSEMBLY WELDMENT (SAME, EXCEPT AS SHOWN)

(CANADIAN VERSION)

DETAIL F
SCALE 0.500

PREMIER AVIATION, INC.

3000 Aviation Parkway, Grand Prairie, Texas 75050

DATE: 1978 08 01

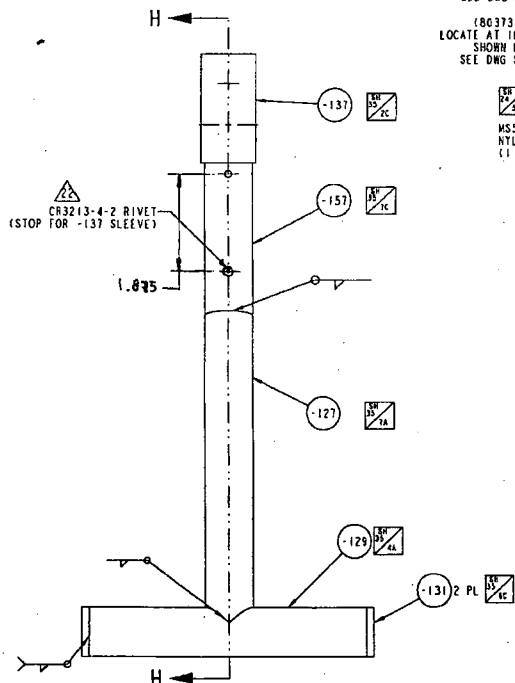
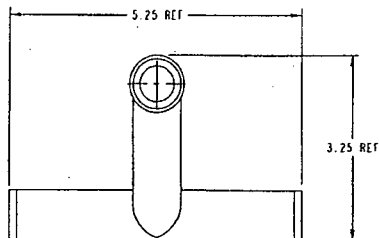
DESIGN: B67-43001

SCALE: 1/16" = 1"

FIGURE: 5 OF 25

ORIGINAL

NO DISC
A
WITHOUT THE
ORIGINAL
COPY
RETURN TO
ENGINEERING
SECTION
UNCONTROLLED COPY
UNCONTROLLED COPY

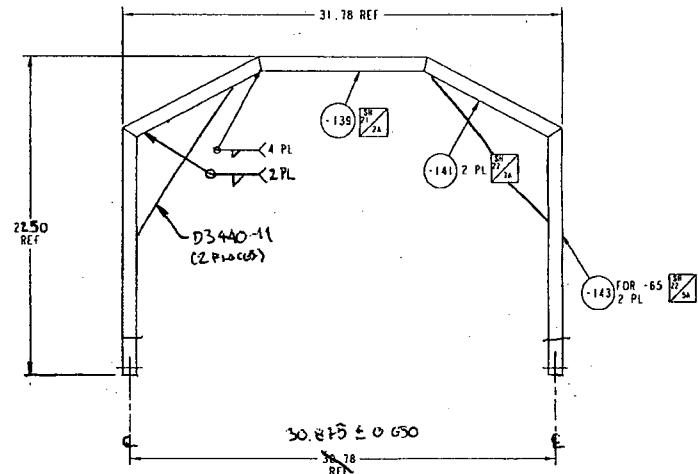
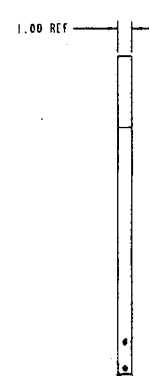


CL-40-SBP-3 DETENT REF
LOCATE AT INSTALLATION,
SHOWN HERE FOR REF
SEE DWG SH3 AND SH4

80373 SET PIN REF
LOCATE AT INSTALLATION,
SHOWN HERE FOR REF
SEE DWG SH3 AND SH4

MS1659-6
NYLON WASHER (2)
(1 EA SIDE -135)

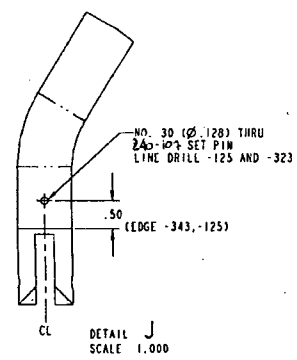
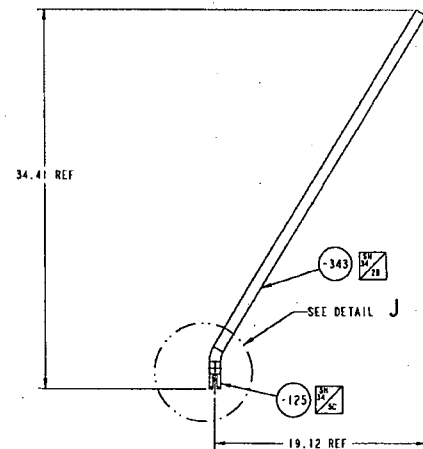
SECTION H-H



RELEASED
06.01.20

~~-63~~ BASE ASSEMBLY (SHOWN)
(COMMERCIAL VERSION)
SCALE 0.250

-47 BASE ASSEMBLY (SAME, EXCEPT AS SHOWN)
(CANADIAN VERSION)



① -37 TUBE ARM ASSEMBLY
SCALE 0.200

PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75050
SIZE: 11x17 (1/4" = 1")
D: OSUV8 B67-43001
SCALE: 1/4" = 1" SHEET: 15 OF 25

ORIGINAL

NO. 41501
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
FOR COPY